

Work Order ID 145721

Friday, May 06, 2016 10:43:34 AM

145721

Page 1

Item ID: D3704-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Escutcheon

Start Date: 5/20/2016 Start Qty: 400 ***4***

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 400 ***4***

Customer:

Reference:

Approvals: Process Plan: gm Date: 16/05/09 Tooling: SPC 17/1/13

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3704	C

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 3.25" LONG

8

0

DAS
20
9-89

16-06-01

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA807

DWG REV: CFOLIO REV: 1A

DEBURR

8

1

DAS
20
9-89

16-06-02

P.T.O.

DQA:

Date: 16.08.09



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/07/17

Work Order update only ☐

Work Order: 145 721		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D3704-3		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5919		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-06-02		Step #: 100		QTY Effective: 1				MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				DAS 9 16-06-02			
Put part in jig the wrong way and machined the ear off.		Scrap & Replace B 134 158				Completed By			
						DAS 20 16-06-02			
						Lead hand / Supervisor Approval Verification			
						DAS 14 16/06/02			
						QC / QA Coordinator Approval			
						DAS 9 16-06-02			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☒	Positioned Wrong ☒				
Design ☒	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Friday, May 06, 2016 10:43:34 AM

145721

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/20/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 5/26/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

0.00

130

QC

Memo

0.00

Quality Control

DAS
14
9-89

16/06/03

0.00

140

HandFinish

Memo

0.00

Hand Finishing

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 145721

Friday, May 06, 2016 10:43:34 AM

145721

Page 3

Item ID: D3704-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Escutcheon

Start Date: 5/20/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>3052</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

8
JUN 09 2016

8
JUN 09 2016

~~MLJ JUN 11 2016~~

MLJ JUN 10 2016

dm 16/07/04

Qty 8 - scrapped on w/o
148223

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>16-06-27</u>		Step #: <u>170</u>		QTY Effective : <u>8</u>			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Picklist Print

Friday, May 06, 2016 10:43:33 AM

Page 1

Work Order ID: 145721

145721

Parent Item: D3704-3

D3704-3

Parent Item Name: Escutcheon

Start Date: 5/20/2016

Required Date: 5/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25		Purchased	No				f	19.4170		1.04			

M6061T6B1 500X01 250

6061-T6 Bar 1.50 x 1.25

2.333' + .283'

DAS
20
9-89

16-06-01

Location

MAT003

m134158

Loc Qty

19.417

19.417

Loc Code

2.333' + .283' 16-06-02 L.L.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

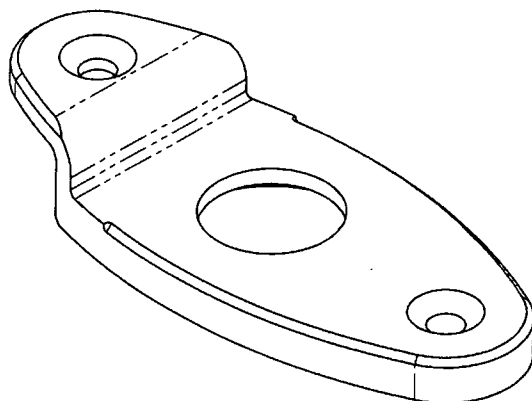
DART AEROSPACE LTD		Work Order:	145721
Description: Escutcheon		Part Number:	D3704-3
Inspection Dwg: D3704 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

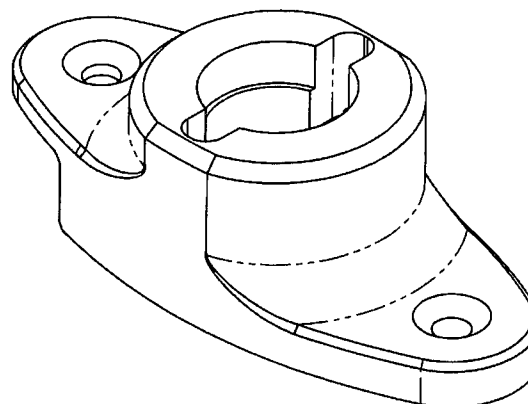
Drawing Dimension		Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.22	+/-0.030	1.221	✓		SLIO	Vern
0.610	+/-0.010	.6075	✓		↓	
Ø0.170	+0.005/-0.001	.171	✓		↓	
Ø0.322 x 100°	+/-0.010 x +/-0.5°	.322	✓		Height gauge	
1.063	+/-0.010	1.063	✓		"	
2.125	+/-0.010	2.124	✓		SLIO	
1.054	+/-0.010	1.052	✓		↓	
0.206	+/-0.010	.206	✓		↓	
Ø0.440	+0.005/-0.001	.441	✓		↓	
.850 0.500	+/-0.010	.850	✓		↓	
0.500	+/-0.010	.500	✓		↓	
0.125	+/-0.010	.125	✓		Rad gauge	
R0.06	+/-0.030	.062	✓		SLIO	
0.625	+/-0.010	.625	✓		Rad gauge	
R0.156	+/-0.010	.156	✓		"	
R0.03	+/-0.030	.030	✓		SLIO	
0.03 x 45°	+/-0.030 x +/-0.5°	.032	✓		↓	
Ø0.755	0.005/-0.001	.756	✓		↓	
0.175	+/-0.010	.172	✓		↓	
0.218	+/-0.010	.218	✓		↓	
0.435	+/-0.010	.436	✓		↓	
0.220	+/-0.010	.221	✓		↓	
0.06 x 45°	+/-0.030 x +/-0.5°	.070	✓		↓	
Ø0.686	0.008/-0.001	.688	✓		↓	
Ø0.630	0.008/-0.001	.631	✓		↓	
.67 0.675	+/-0.030	.670	✓		↓	

Measured by: DAS 20 9-89		Audited by: DAS 14 9-89		Preliminary Approval:	
Date: 16-06-01		Date: 16/06/03		Date:	

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	
B	13.02.27	Dimensions updated per Dwg Rev C	KJ	



D3704-1 ESCUTCHEON



D3704-3 ESCUTCHEON

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-X" AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT:
- D3704-1 = 0.04 lbs
- D3704-3 = 0.11 lbs

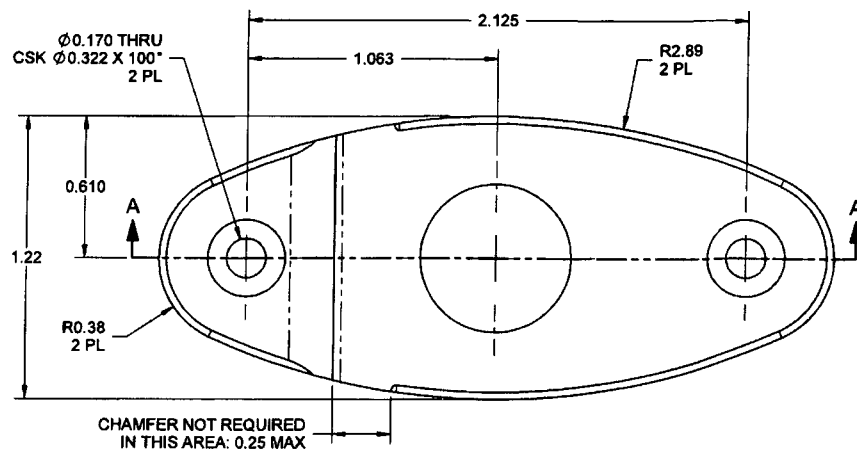
UNDER REVIEW

URF16-533 MB

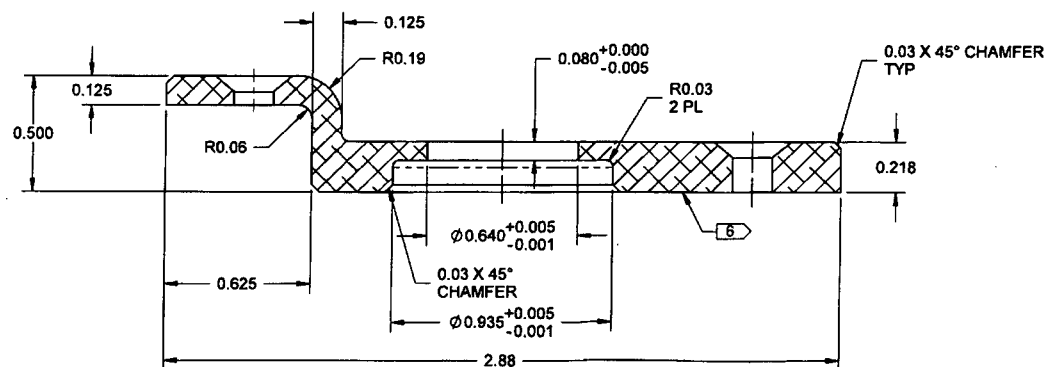
16.05.31

RELEASED
2013-01-14
MB

C	Ø0.630 +0.005/-0.000 WAS Ø0.628 (ZN B5-3); 0.725 WAS 0.685 (ZN B5-4). REASON: PART12-188/CIR12-4.	MB	12.12.08
B	ADDED D3704-3. REASON: COMPATIBILITY WITH AA'S HANDLE.	MB	09.03.17
A	NEW ISSUE	MB	08.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3704	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ESCUTCHEON	NTS
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D3704-1 ESCUTCHEON



SECTION A-A

UNDER REVIEW

URF16-533 MB

16.05.31

RELEASED
2013-01-14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3704	REV. C
MFG. APPR.		TITLE	SCALE
APPROVED		ESCUTCHEON	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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URF16-533 MB
16.05.31

RELEASED
2013-01-14

DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			DRAWING NO. D3704	
CHECKED			REV. C	
MFG. APPR.			SHEET 3 OF 3	
APPROVED			SCALE	
DE APPR.			NTS	
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